

Work Order ID 51619

August 27, 2009 8:27:14 AM

Page 1

Item ID: D3535-39 **GY**

Accept

Revision ID: B

Item Name: Wearshoe

Setup Start

Stop

Start Date: 8/27/09 Start Qty: 12.00

Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 1 IDwg Rev: B 1 Prog Rev: B 12-
Deburr if necessary

B 9-10-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8/27/10/07

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51619

August 27, 2009 8:27:14 AM



Page 2

Item ID: D3535-39

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 8/27/09 Start Qty: 12.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. <input type="checkbox"/> Identify as D3535-41 <input type="checkbox"/> Form Joggle on brake using Jig DT8158 as per Dwg D3535	0.00				13	0		
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 11:45 FINISH TIME: 12:15	0.00							

8809/10/08

275 02/10/08

HB

BR 09-10-8

13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51619

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Page 3

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Revision ID: B

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Start Date: 8/27/09 Start Qty: 12.00

Required Date: 9/11/09 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: F7B18

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W 09/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:14 AM

Work Order ID: 51619

Parent Item: D3535-39RevB

Parent Item Name: Wearshoe

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	63.3940	12.0126	13.0136		



304/316 .040 Sheet

WB 9-10-7

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

63.39404737

110076

31.73

111571

31.6640474

112S67

112S67

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	X			
32.775	+/-0.010	32.775	X			
29.275	+/-0.010	29.275	X			
25.775	+/-0.010	25.775	X			
23.250	+/-0.010	23.250	X			
19.750	+/-0.010	19.750	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.00	X			
9.00	+/-0.030	9.00	X			
28.00	+/-0.030	28.00	X			
Ø0.188	+0.005/-0.001	0.192	X			
1.885	+/-0.010	1.889	X			
0.300	+/-0.010	0.300	X			
0.300	+/-0.010	0.303	X			
0.038	+/-0.010	0.035	X			

Measured by:	IB
Date:	9-10-07

Audited by:	S
Date:	09/10/07

Prototype Approval:	N/A
Date:	N/A

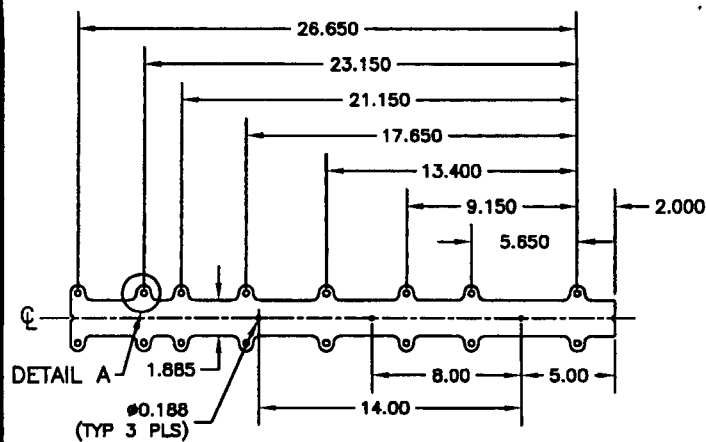
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART

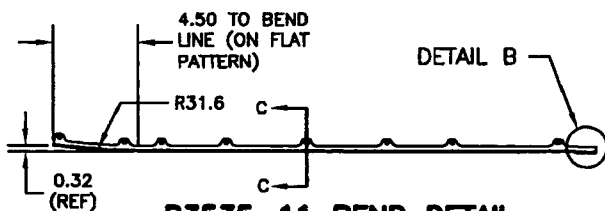
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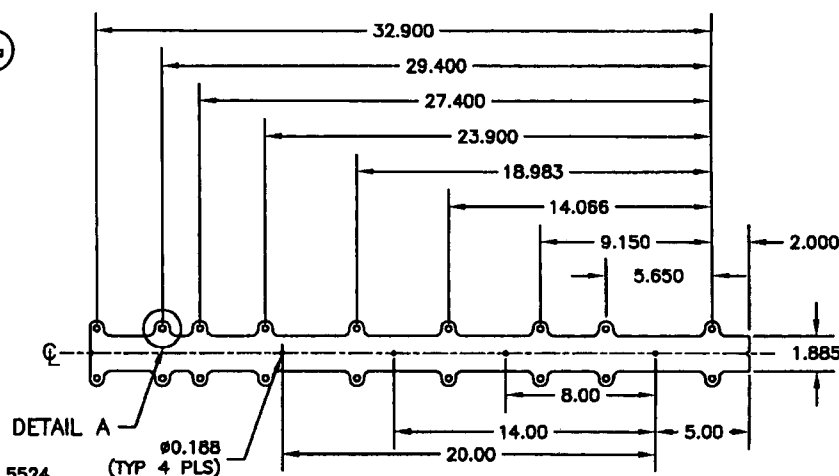
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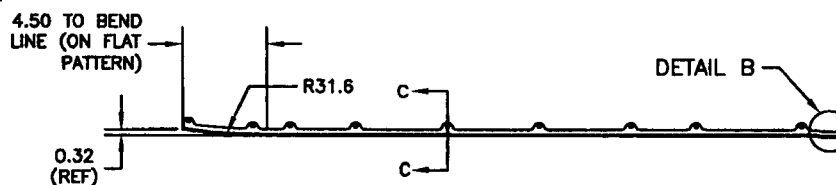
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
		SCALE
		1:10
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B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

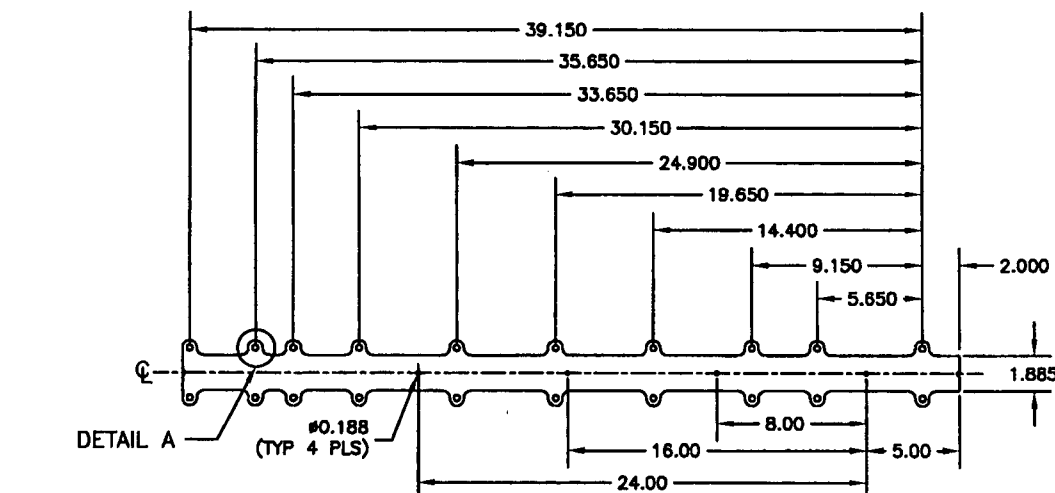
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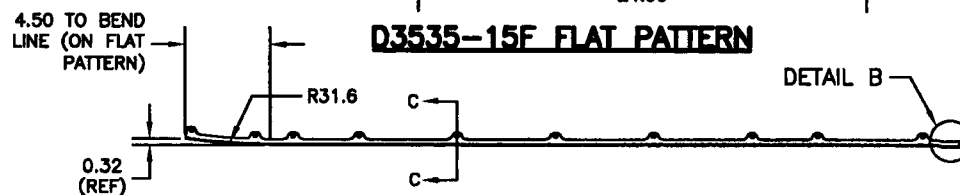
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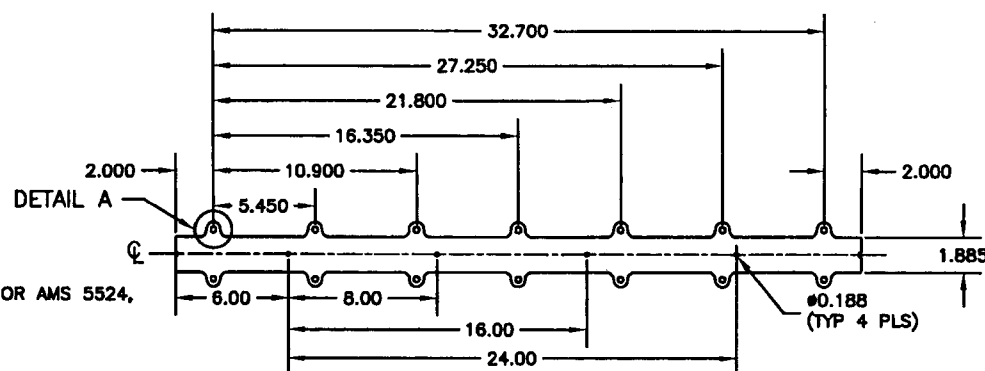
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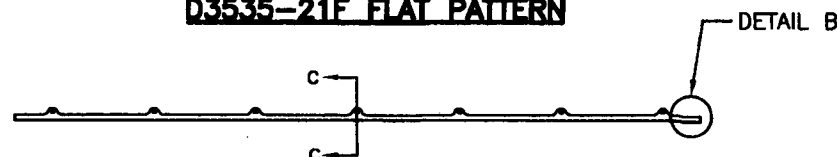
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

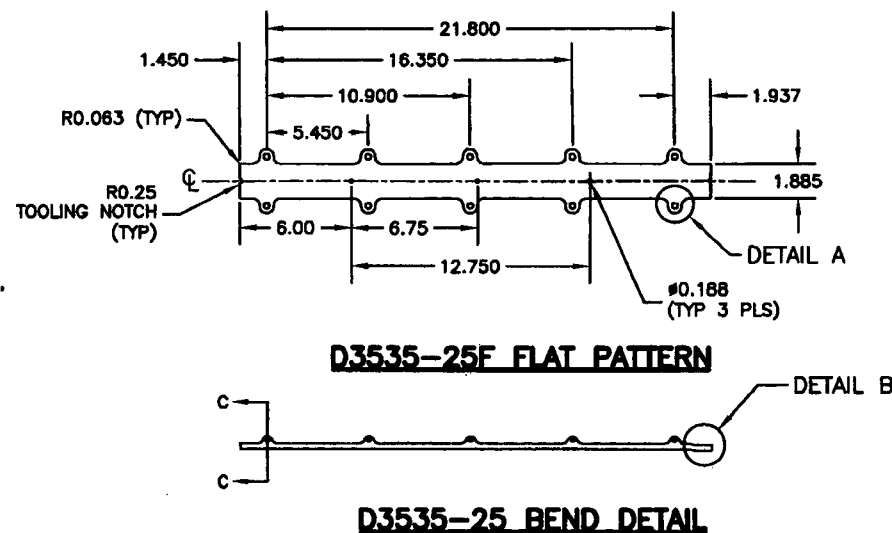
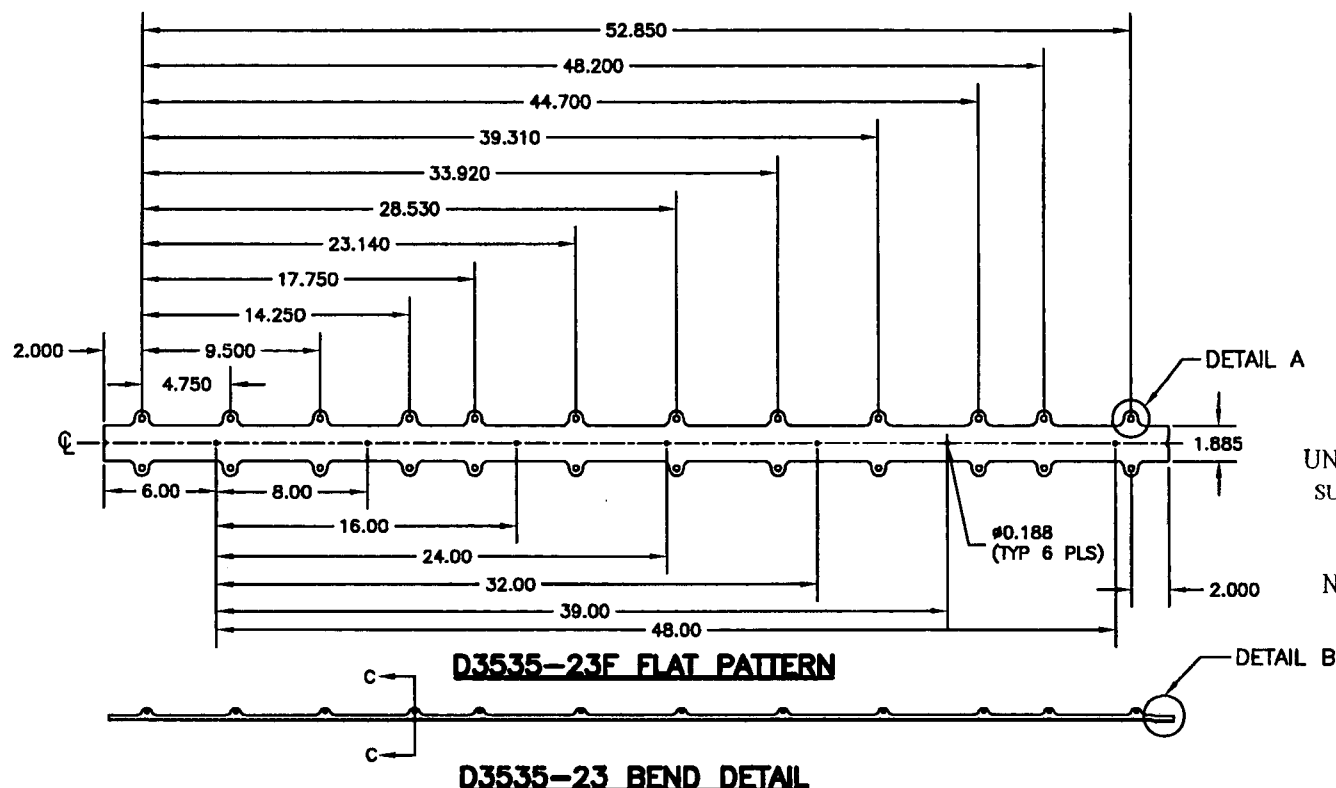
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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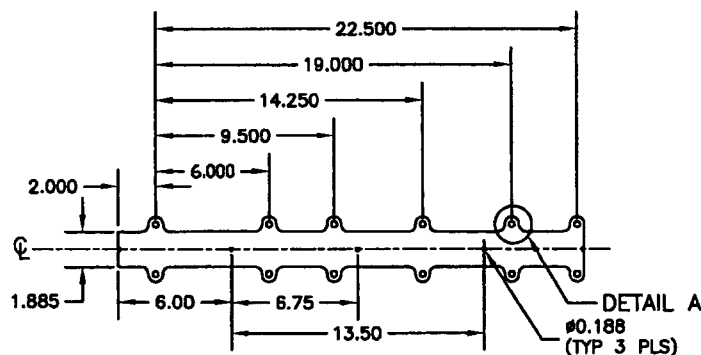
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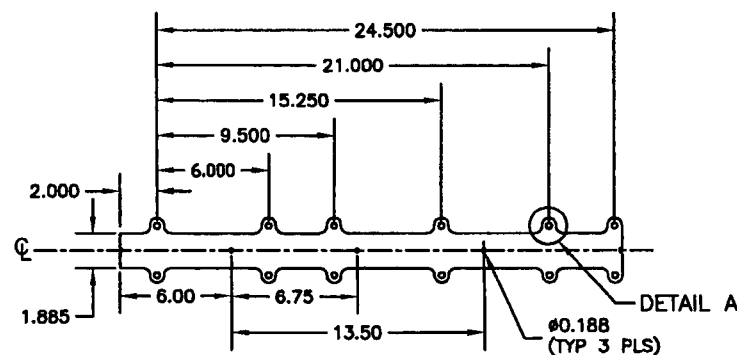
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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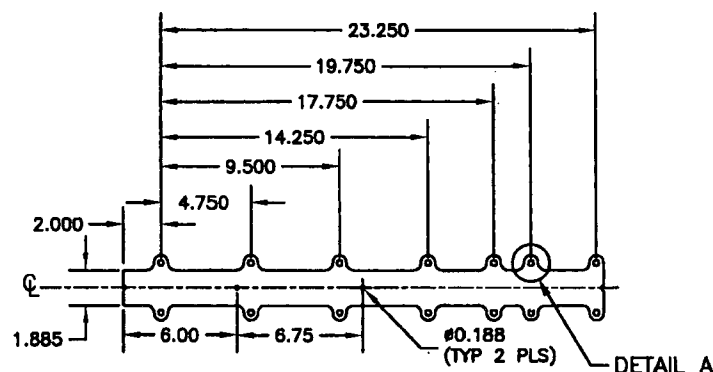
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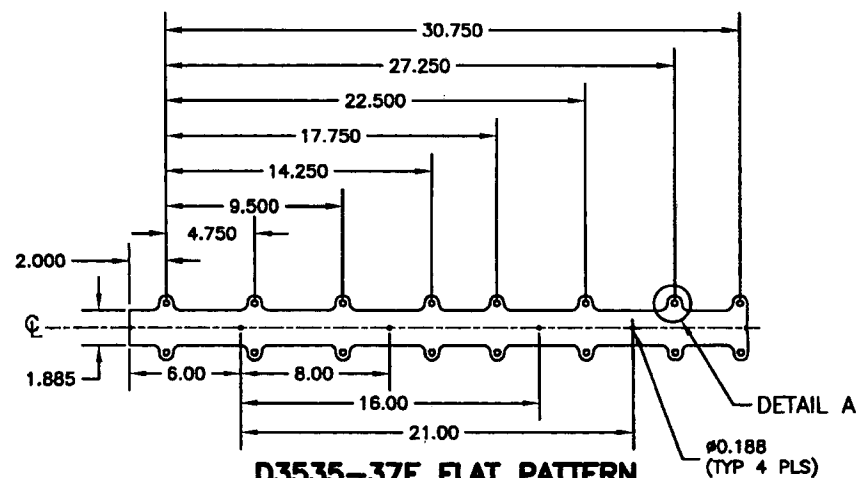
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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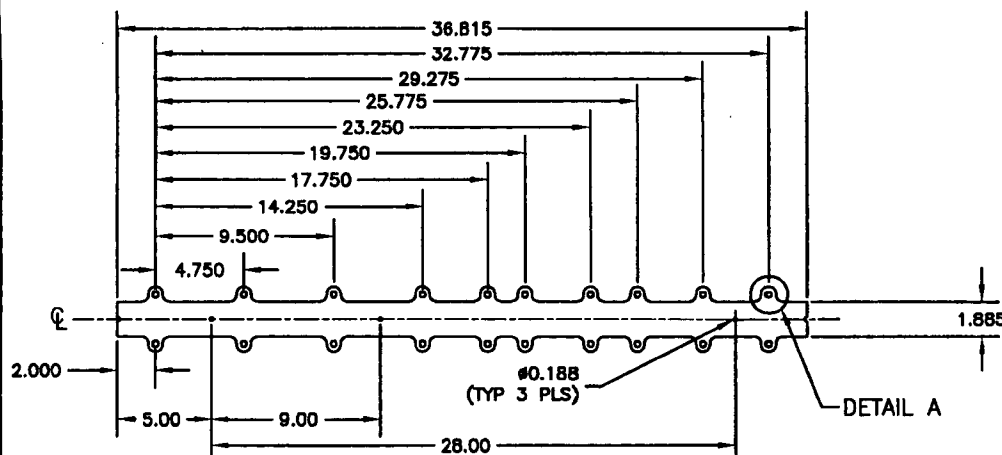
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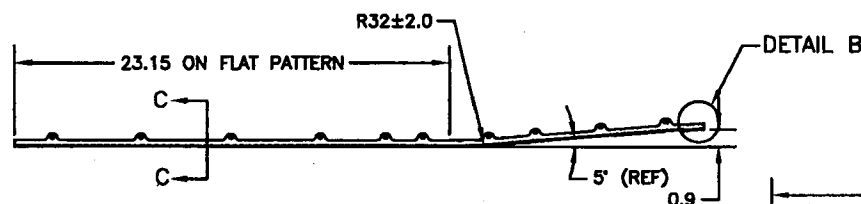
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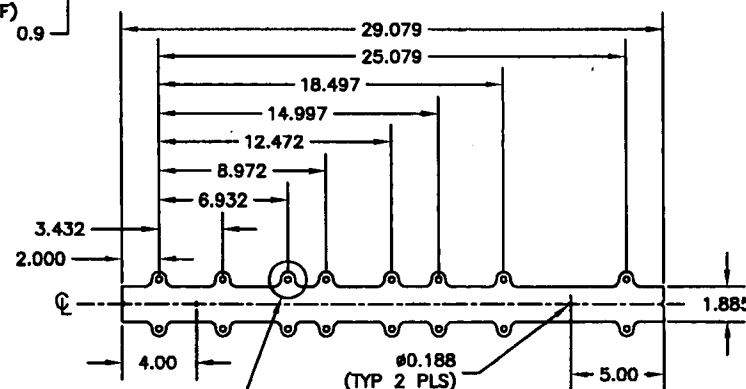
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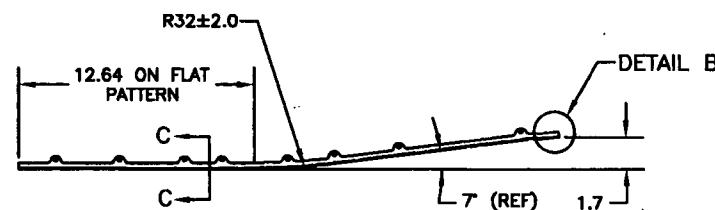
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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		REV. B

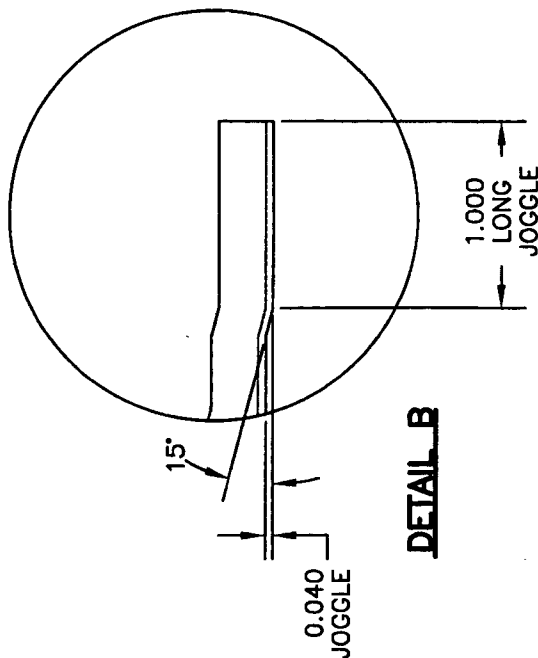


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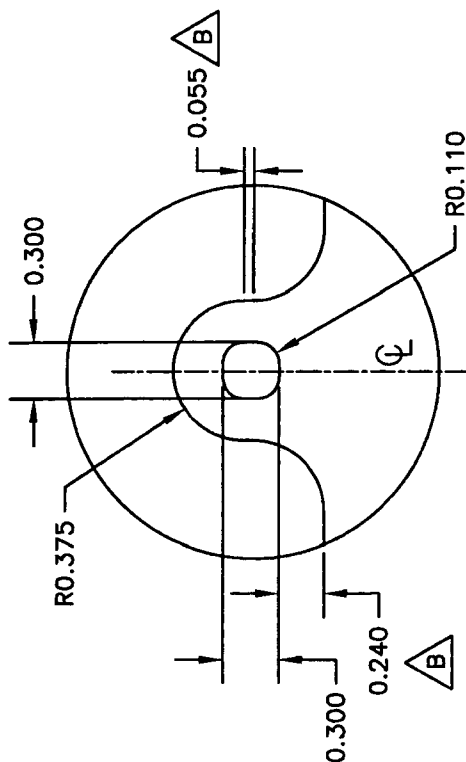
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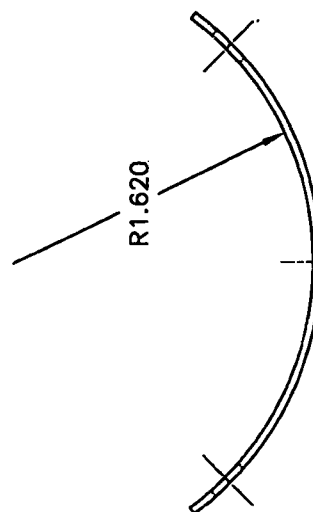
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DETAIL B



DETAIL A



SECTION C-C

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